

Date: Tuesday, 4/17/2007 3:47:23 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET		
Job Number	: 31895					
Estimate Number	: 10710					
P.O. Number	: N/A		Part Number	: D32111		
This Issue	: 4/17/2007	S.O. No.	: N/A	Drawing Number	: D3211 REV A1	
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: A1		
Previous Run	: 31428		Material	: N/A		
Written By			Due Date	: 4/30/2007		
Checked & Approved By	: JLM 07.04.18		Qty:	12	Um:	Each
Comment	Est Rev:A	New Issue	05-11-17	JLM		
	Est Rev:B	Now on Waterjet	06-10-24	JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3.063 sheet
		
		
	Comment: Qty.: 1.4753 sf(s)/Unit Total : 17.7030 sf(s)	
	Material: 2024-T3 (QQ-A-250/4) 0.063" thick	
	(M2024T3S.063)Identify as D3211-1	
	Batch: <u>M104676</u> <u>ml 07 06 11</u>	
2.0	WATER JET	FLOW WATER JET
		
		
	Comment: FLOW WATER JET	
	1-Cut as per Dwg D3211	
	Dwg Rev: <u>A1</u>	
	Prog Rev: <u>A1</u>	
	<u>ml 07 06 11</u>	<u>(12)</u>
	2-Deburr if necessary	<u>SAD</u> <u>07/06/11</u> <u>12</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
		
	<u>ml 07 06 11</u>	<u>(12)</u>
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
		
		
	<u>JULY 06 12</u> <u>(12)</u>	
	Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
		
	Comment: SMALL & MEDIUM FAB RESOURCE 1	
	Deburr	<u>600</u> <u>07/06/19</u> <u>(12)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/07/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BRACKET

Job Number: 31895

Part Number: D32111

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend D3211-1 Stack as per Dwg D3211

SB 07/07/16

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/16 X 12

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005.4.1

M-1 07-07-17

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 07/07/21

10.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005.4.3

M-1 07/07/21

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

E/S 07/07/23 (Qx)

12.0 QC21 FINAL INSPECTION/W/O RELEASE



(Qx)

Comment: FINAL INSPECTION/W/O RELEASE

07/07/23

Job Completion



U 07-07-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31895
Description: Bracket	Part Number:	D3211-1
Inspection Dwg: D3211 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: M. MM
Date: 07/06/11

Audited by:	Er
Date:	07/06/11

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	JF

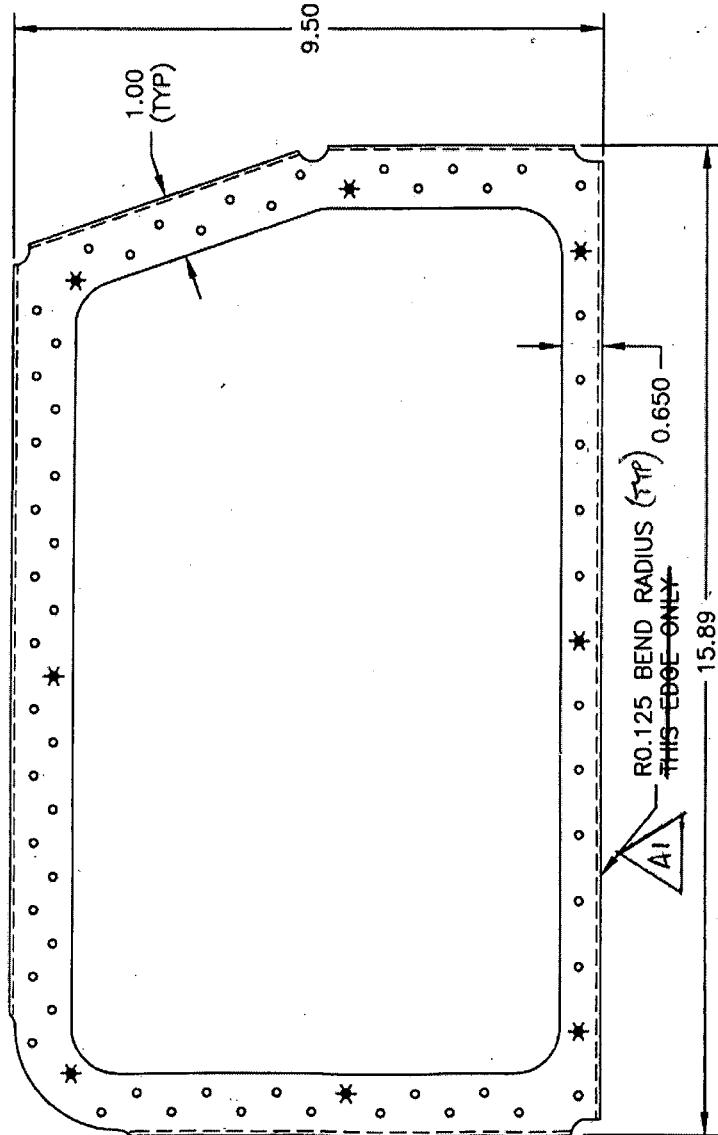
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3211	SHEET 1 OF 2
DATE		TITLE	SCALE
03.09.03		BRACKET	1:3
A	03.09.03	NEW ISSUE	
A1	03.12.05	CHANGE ALL BEND RADIUS TO R0.125	

RELEASED

03.09.15 *

D3211-1 BRACKET
 MACHINE PER DRAWING FILE "D3211-A2.DWG"
 CHECK PER TEMPLATE D3211-1T1
 MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
 USE MINIMUM BEND RADIUS OF ~~0.188"~~ EXCEPT WHERE INDICATED ~~0.125"~~ A1
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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 NO. 31895

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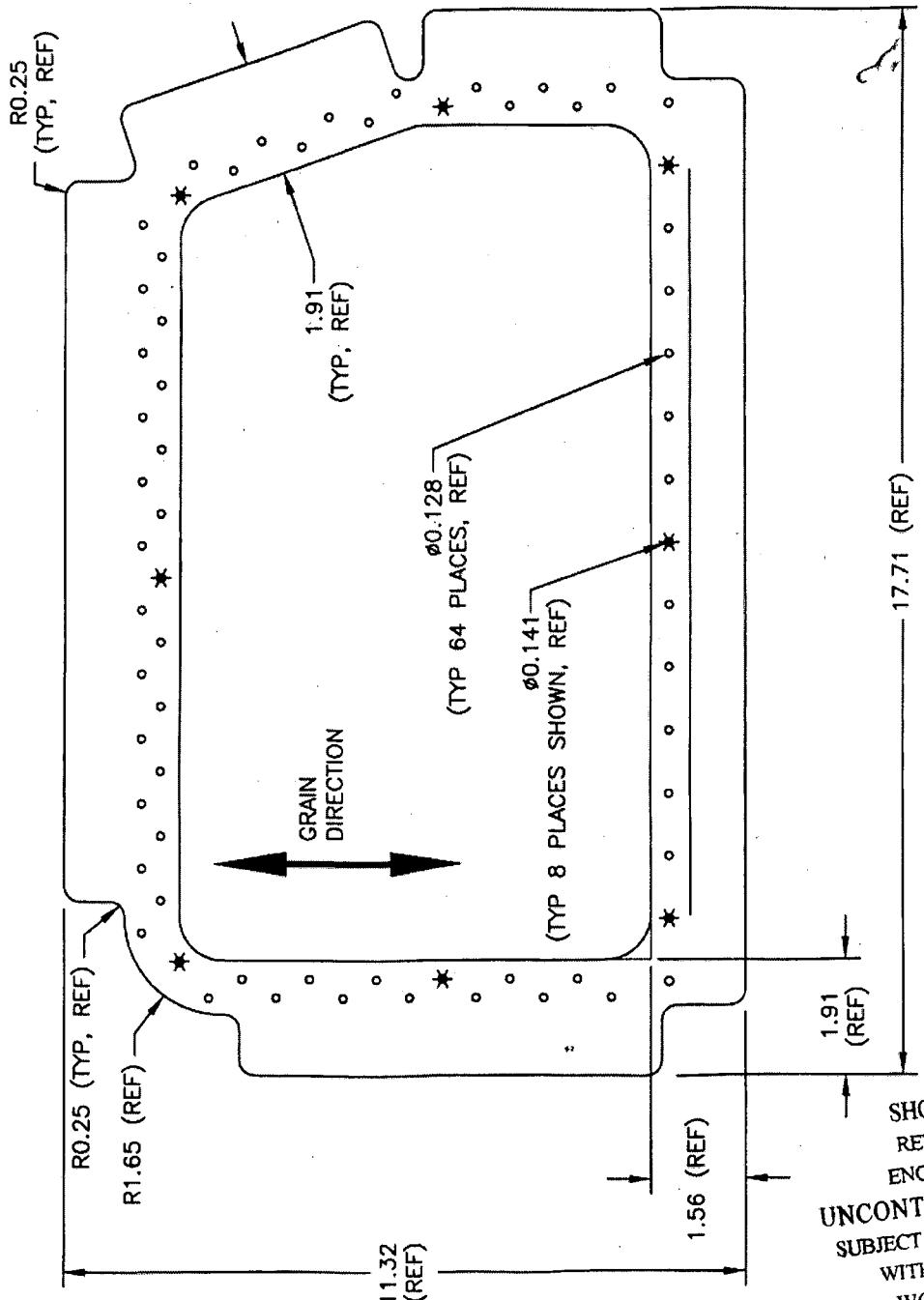
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3211
DATE	TITLE	REV. A SHEET 2 OF 2 SCALE 1:13

RELEASED
03.09.03

D3211-1 FLAT PATTERN



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